Work Orde May-01-13 7:29		0872		*100					Page 1			
Item ID: Revision ID:	D3015-7		· A	Accept	*N900	040	100)* s	Setup	Start	*N:	S1*
	Lock Nut	000	100							Stop	*N!	S2*
	4/30/13 4/30/13	Start Qty: 80.00 Req'd Qty: 80.00	*20* *20*		Cust Item Customer:							
Approvals:	Process Pla	in: MLJ	Date: 13-05-03	Tooling:	D	Date:				Start	*NI	R1*
••			Date:	SPC (Y/N):	D	ate:				Stop	*NI	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr								± 1 1		
D3015	Rev	B. CLINI										
100				0.00								
100 Purchasing Purchasing		Possible Sup	19757 SS locknut with nylon inser plier: Acklands P/N: FLMN ase note required	0.00 t O21-005-0000			:	_ CX	12	ole:	5/03	100_
110		Receive & Inspect for Da	mage & Mat'l Certs	0.00		,				//	1,	
110 Packaging Packaging		Memo Ensure Mate	rial Release Note is attached	0.00							3/5/	110
120 * 120 *		QC6- Inspect dimensions	to drawing	0.00				100				
QC Quality Control		Memo		0.00 B	S. 15			100				

			į								DQA:	Date:	
NCR: Y	es /	No				WORK ORDER NON-CONFORMANCE / UPDATE				DATE	QA Closed:	Date:	•
Work Orde	er:	<u> </u>				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No. NCR No.			Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite		Small Fab		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other					
Root					Descri	ption of work order update	lni	tial	Act	tion	Sign &		
Cause	D	ate	Step	Qty		or Non-conformance	Chie	f Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling													
Operator	-	1											
Material							1						
Setup													
Other				1									
Process			 										
Supplier	П												
Training				1	\								
Unapproved	П												
						F	AULT	CATE	GORY				
Landi	ng Gear					General					_		_
	Ben	ding				Bend	G	irain			Ovalized		Pressure/Forced
	Cen	tre No	t Conce	ntric to	o/s	BOM/Route	Шн	ardwa	re		Over/Under	tolerance	Temperature/Cure
	Cra	cks				Broken/Damaged	L In	specti	on Incomplete	<u> </u>	Part Incorred	ct	Weld
	Cru	shed/C	rimped			Burrs	ln	struct	ions Incomplete/I	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuf	fs				Contamination	L N	/lainte	nance		Part Moved		
	Hea	at Trea	t			Countersink	\square	1islabe	led	<u>L</u>	Positioned V	Vrong	-
	Inst	oection	Strip in	Tube		Cut Too Short	∐v	1isread	1		Power Loss/	Surge	Other
	Rip	ples in	Bend			Drill Holes		ffset					
	Tor	que W	aves in E	Extrusio	n [Drawing		ut of C	Calibration			· · · · · · · · · · · · · · · · · · ·	
	Tur	ning Se	equence	!		Finish		ut of S	Sequence				
	Wave/Twist in Tube					Folio	0	utside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Quality Control

13-5-13

										DQA:	Date	e:
NCR:	res / No				WORK ORDER NON-CONFORMANCE / UPDATE							*
				~				QA Closed:	Date	2:		
Work Orde	or.				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
WOIR OIG					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	No.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
			Use-as-is	1 1		noforming	Finishing	Rec/Stor	e/Packaging	Other		
NCR No.			Work Order Update		•	Large Fab	Composite]	Supplier			
Root	T	1	1	Descri	ption of work order update		nitial	Ac	tion	Sign &		T
Cause	Date	Step	Qty	ı	or Non-conformance	1	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data		1										
Equip/Tooling		1				ļ						
Operator		l¦										
Material		li								}		
Setup		li.										
Other												
Process		ŀ										
Supplier												
Training						ļ						
Unapproved												
					F/	AUL	T CATE	GORY				
Landi	ng Gear	i I			General					•	_	_
	Bending	. 			Bend	Ш	Grain			Ovalized		Pressure/Forced
	Centre I	ot Conce	ntric to	o/s	BOM/Route	Ш	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Ш	Inspecti	on Incomplete		Part Incorred	—	Weld
	Crushed	Crimped	·		Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs	į			Contamination	Ш	Mainte	enance	<u></u>	Part Moved		
Heat Treat		Countersink	Ш	Mislabe	eled		Positioned W		_			
	Inspecti	on Strip ir	า Tube		Cut Too Short		Misread	1		Power Loss/S	Surge	Other
	Ripples	n Bend			Drill Holes		Offset					
	Torque	Waves in	Extrusio	n _	Drawing		Out of 0	Calibration				
	Turning	Sequence	9		Finish		Out of S	Sequence				·
Wave/Twist in Tube Folio					Folio		Outside	Dimensions				

Picklist Print

May-01-13 7:29:11 AM

Page 1

Work Order ID:

100872

Parent Item:

D3015-7

Parent Item Name:

Lock Nut

Start Date: 4/30/13

Required Date: 4/30/13

Start Qty: 80.00

Required Qty: 80.00

Comments:

IPP: A01.06.08New Issue SM

IPP rev:B

11.01.06 CHG

	Supplier p# DD	vef:EC												
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
PFSLNNM5S1		Purchased	No			100	Each	0.0000	1	X	100			•
Lock Nut											,00	* A % E # F 7		

/c/3/0/10 (100)

		į									DUA:	Da	te:	
NCR: Y	es / No				WORK ORDER NON-O	100	NFORM	MANCE / UPI	DATE		QA Closed:	Da	te:	v
Work Orde	or.				DISPOSITION	AGAINST DEPARTMENT/PROCESS								
Part No. NCR No.				Scrap Machining Small Fab Use-as-is Thermoforming Finishing			Crosstube Small Fab Finishing Composite	Prod. Eng. (Rec/Store/Packa				Engineering Quality Other		
Root		!	,	Descri	ption of work order update	I	nitial	Act	ion		Sign &			
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption		Date	Verificatio	n	QC Inspector
Doc/Data		1												
Equip/Tooling		H												
Operator											:			
Material		l¦								į				
Setup		ļ												
Other		İ	1											
Process		ļ				1					,			
Supplier		!												
Training										i				
Unapproved						<u> </u>				į				
					F.	AUL	T CATE	GORY						
Landi	ng Gear				General				_		i	,	_	•
ı.	Bendin	g			Bend	L	Grain				Ovalized			Pressure/Forced
	Centre	Not Conce	entric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
	Cracks	İ			Broken/Damaged	L	Inspection Incomplete				Part Incorrec	t		Weld
	Crushe	d/Crimped	i		Burrs		Instruct	ions Incomplete/U	Inclear		Part Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs				Contamination	Mainte	Maintenance			Part Moved				

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

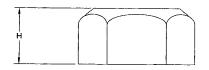
Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

SPECIFICATION CONTROL DRAWING



D3015-X LOCKNUT

PA	RT NUMBER	SIZE	HEIGHT H	POSSIBLE SUPPLIER
	D3015-1	1/4-20 UNC	0.31	ACKLANDS, P/N PFSLNNC14S1
	D3015-3	5/16-18 UNC	0.34	ACKLANDS, P/N PFSLNNC516S1
	D3015-5	7/16-14 UNC	0.46	ACKLANDS, P/N PFSLNNC716S1
	D3015-7	M5	0.19	ACKLANDS, P/N FLMN021-005-0000

REFORMAT DWG, -7 P/N NOW FLMN021-005-0000 WAS LNNM5S1 (ZN B8-1), PAR 09-020 CP 09.07.08 В ADD D3015-7 KJ 03.07.15 Α NEW ISSUE DS 01.05.03

+ PNTO JUNCALITER PRINCE THE ATTROUTED COPY TO A CONDUMENT

A TOROR

10.0872 MLJ 13-05-03

REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. C D3015 MFG. APPR. SHEET 1 OF 1 TITLE APPROVED SCALE LOCKNUT DE APPR. NTS

DATE 09.07.08 COPYRIGHT © 2001 BY DART AEROSPACE LTD
THIS DODARDIT IS PRIVATE AND CONFEDENTIA, AND IS SUPPLIED ON THE EXPRESS ORNOR
HOST TO BE USED FOR MY PURPOSE OR COMED OR COMMANICATED TO MY OTHER PERSO.

1) MATERIAL: SS LOCKNUT WITH NYLON INSERT 2) FINISH: N/A

2) FINISH: NIA 3) TOLERANCES: ALL DIMENSIONS SHOWN AS REFERENCE 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: NIA 6) IDENTIFICATION: NONE 7) WEIGHT: NIA

8

D

C



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19797

Purchase Order Date 5/6/2013 PO Print Date 5/6/2013

Page Number 1 of 1

Order From:

VC-ACK001

ACKLANDS - GRAINGER INC. P.O. BOX 2970 WINNIPEG, MB R3C 4B5

CA

Contact Name

Vendor Phone Vendor Fax

613 632 2739

613 632 5386

Vendor Account Nbr

Buyer

Brigitte Golden

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms Currency Net 30 CAD

FOB

Destination-Collect

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

Line Nbr Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable U	Req Qty/ nit of Measure	Ship Method	Unit Price	Extended Price
PFSLNNM5S1	Lock Nut	5/10/2013 Yes	100.00 Each	Yours ppd	\$0.0800	\$8.00

Special Inst:

AS PER DWG: D3015 REV:C B100872

PO Total:

\$8.00







No substitution or deviation without consent. Certificate of Conformity or Material

NO

Certification required - YES

ACKLANDS ACKLANDS - GRAINGER INC. R E M I PACKING SLIP ONLY INVOICE TO FOLLOW 765 CAMERON ST. **GRAINGER** ACKLANDS - GRAINGER INC. PO BOX 2970 HAWKESBURY ON K6A 2B7 (613) 632-2739 PAGE PAGE NO **WINNIPEG MB R3C 4B5** PACKING SLIP# EXPEDIEZ T O 1 of 1 ACTUREZ 1417 0425965 1 DART AEROSPACE LTD 1270 ABERDEEN ST DART AEROSPACE LTD 1270 ABERDEEN ST HAWKESBURY K6A 1K7 HAWKESBURY ON K6A 1K7 À NO. DU CLIENT CUST. NO. NO DE REFERENCE DU CLIENT CUST. REF. NO. NO. DE LICENSE PROVINCIALE P.S.T. LIC. NO. NO. DU CONTRAT CONTRACT NO. EXP. DIRECTE DATE DE LA COMMANDE DIR. SHIP ORDER DATE DATE DE LA FACTURE INVOICE DATE 19797 1726280 N/A - HST Ν 05/07/2013 VENDEUR SALESPERSON 05/10/2013 TERMES TERMS NO.DE VERSEMENTS NO. OF PMTS. M.E.P. M.B.P. DATE DU PREMIER VERSEMENT FIRST PAYMENT DATE APP. DE CREDIT S'APPLIQUE AU NO DE FACTURE CREDIT AUTH APPLY TO INVOICE NO. COPIES *** NET 30 *** M85 0 0 00/00/0000 08:52 ORDER SEQ. NO. DE PIECE ITEM NO. PRIX DE LISTE SUGG. LIST QUANTITE QUANTITE EXPEDIEE QUANTITY SHIPPED PRIX EXTENSIONNE EXTENDED PRICE PRIX PRICE RORE DE TABLETT QUANTITY PAR PER ESC DIS FLM N021-005-0000 12.43 100 100 C07F EΑ 9.919 THIS ITEM HAS BEEN SUPERCEDED 100 9.92 NYY PFSLNNM5S1 SUPERSEDED BY ABOVE ITEM HST# 88970-1272/TVQ# 1019602903 SOUS TOTAL / SUB TOTAL EXPEDITEUR SHIP VIA 9.92 DATE DE LIVRAISION REQUISE REQUESTED DELIVERY **CUSTOMER PICK UP** 1.29 B - B.O COMMANDE DIF. C- ANNULEE CANCEL D- EXP ORIECTE DR. SHE 9305 0.00 RECU PAR RECEIVED BY 11.21 MONTANT TOTAL TOTAL AMOUNT COPIE DE FILLIÈRE - SUCCURSAI F